

Work Order ID **75979**

75979

November-02-11 10:49:20 AM

Page 1

Item ID: D3299-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fitting

Stop *NS2*

Start Date: 02/11/2011 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/11/02

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3299	Rev C	

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

Cut blank: 2.950" long

Turn as per Folio FA465 and Dwg D3299

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75979

Page 2

N900040100

Setup Start ***NS1***

Stop ***NS2***

8

8

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

115

0.00

115

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA465

FOLIO REV: AA

DWG REV: C

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

QC

Quality Control

Memo

125

QC8- Inspect parts - second check

0.00

125

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75979

November-02-11 10:49:20 AM

Item ID:	D3299-5	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Fitting				Stop	*NS2*

Start Date:	02/11/2011	Start Qty:	8.00	*g*	Cust Item ID:
Required Date:	16/11/2011	Req'd Qty:	8.00	*g*	Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Outsource process-Anodize per QSI017 4.1.10.1

0.00

130

Outsource4

Outsource process - Anodize

Memo

Issue P/O: 15618 Anodize as per Dwg D3299Possible
Supplier: TNM PaintMaterial release note is required

0.00

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Packaging

Memo

Ensure Material Release Note is attached

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75979

75979

Page 4

November-02-11 10:49:20 AM

Item ID: D3299-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 02/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location SP 37	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

SP 11-12-05

12/1/12
MF
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:49:24 AM

Page 1

Work Order ID: 75979

75979

Parent Item: D3299-5

D3299-5

Parent Item Name: Fitting

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A04.10.04New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6H1 625		Purchased	No			100	f	16.5000	0.1917	1.614316			
M6061T6H1 625									**			11/11/17	
6061T6 hex bar 1.625													

Location

Loc Qty

Loc Code

MAT012

16.5

010908

16.5

~~1.625~~

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75979
Description: Fitting		Part Number:	D3299-5
Inspection Dwg: D3299	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.625	+/-0.010	1.625	/	/	SL-9	
1.250	+/-0.010	1.25	/	/		
Ø1.00	+/-0.030	Ø.999	/	/		
Ø0.563	+0.005/-0.000	.563	/	/		
Ø0.302	+0.005/-0.000	.305	/	/	G. A. 25	
Ø0.091	+0.007/-0.008	0.093	✓	/	Vern/6A-01	Milling
Ø0.003	+0.015/-0.000		/	/		
30°	+/-0.5°	30°	/	/	Angle-meter	CNC-Ø3
53°	+/-0.5°	53°	/	/		
1.00	+/-0.030	1.00	/	/		
1.700	+/-0.010	1.695	/	/		
R0.06	+/-0.030	R.06	/	/		
Ø0.476	+0.000/-0.005	Ø.474	✓	/		
MOW for 9/16"-18	Min = 0.5742 Max = 0.5708	.572	/	/		
0.20	+/-0.030	.20	/	/		
0.93	+/-0.030	.93	/	/		
0.150	+/-0.010	.150	/	/		
Ø.696	+0.007/-0.008	.693	✓	/	Vern/6A-01	Milling
Ø0.000	+/-0.010	0.693	✓	/	Vern/6A-01	
Ø0.588	+0.005/-0.000	Ø0.588	✓	/	Vern/6A-01	
0.50	+/-0.030	0.499	✓	/		
2.85	+/-0.030	2.844	/	/		

Measured by: <i>SL/B.A.</i>	Audited by: <i>RA</i>	Prototype Approval:	N/A
Date: 11/12/03	Date: 11.12.04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.313	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	
D	08.09.04	Dimension revised	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

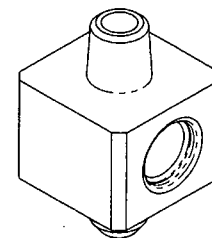
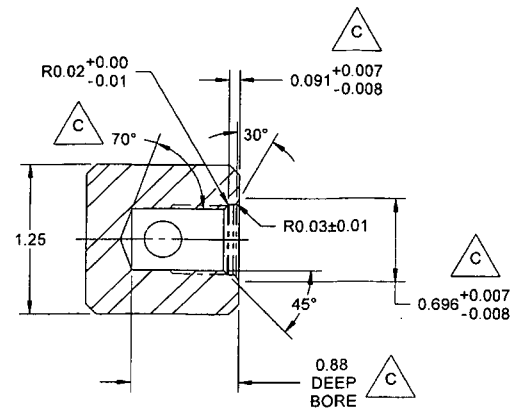
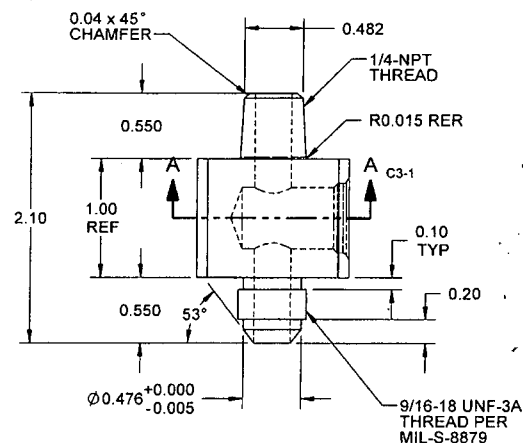
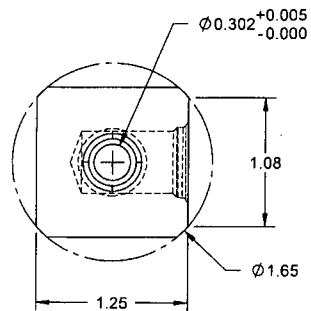
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

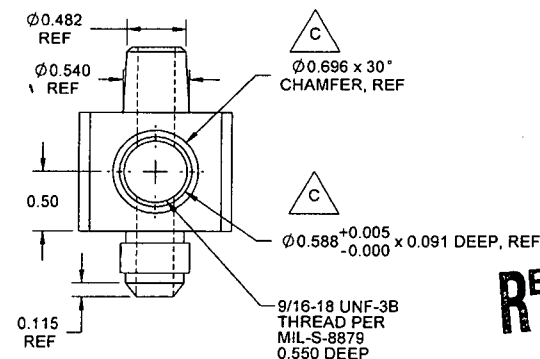
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURNED
ENGINEERED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75979 M.L.J
11/11/08



SECTION A-A C5-1



RELEASED
2010-01-14

D3299-1 FITTING

- NOTES:
- MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2 POSSIBLE SUPPLIER: ANODIZING TMM PAINT
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-1" & B/N USING FINE POINT PERMANENT INK MARKER
 - WEIGHT: 0.42 lbs

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISE MATERIAL BAR WAS HEX BAR (ZN A8-1); ADD -7 (ZN A4-4); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN D2-1, D3-1, C2-1, B2-1, D5-4, C4-4, B4-4, C1-4) PER CAR 09-004	RF	09.12.30
B	1.08 WAS 0.837; Ø302 WAS Ø0.297	RF	05.04.28
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

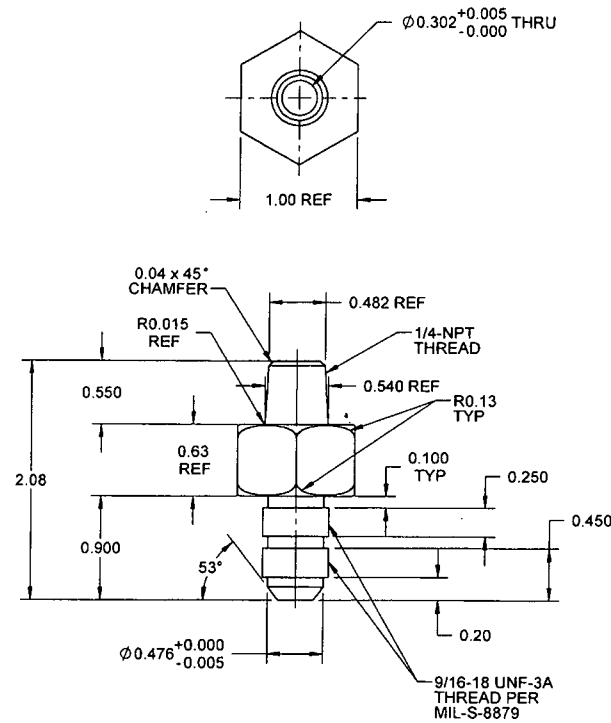
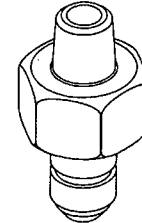
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75979



D3299-3 FITTING

RELEASED
2010-01-14

NOTES:

- MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.00" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.000
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-3" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

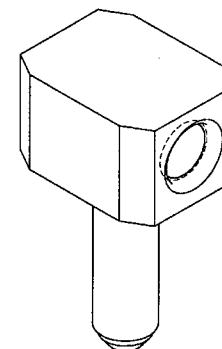
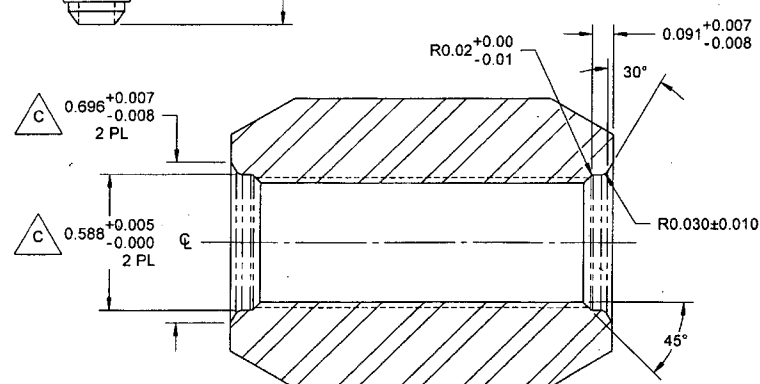
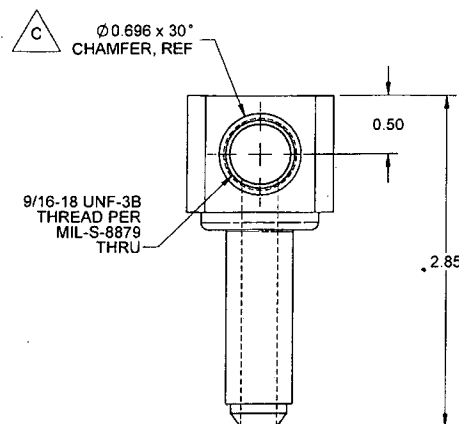
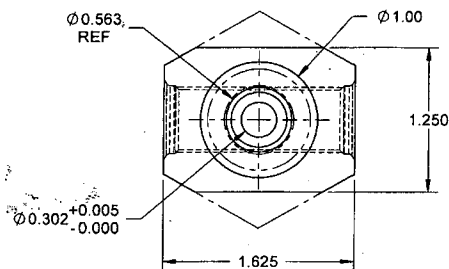
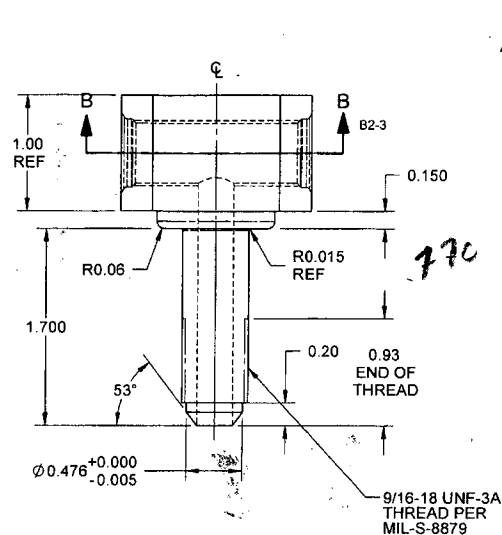
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75979



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-5" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

D3299-5 FITTING

SECTION B-B D6-3
SCALE 2X

RELEASED
R 2010-01-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

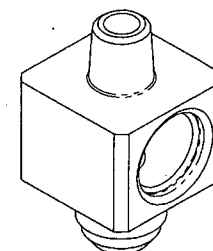
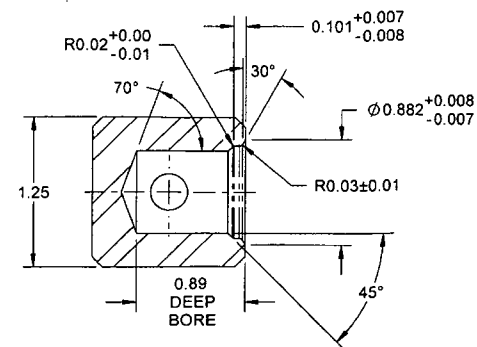
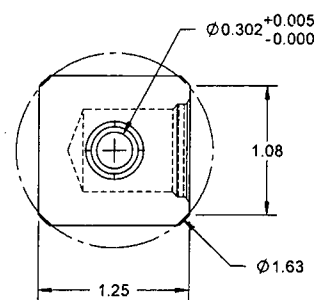
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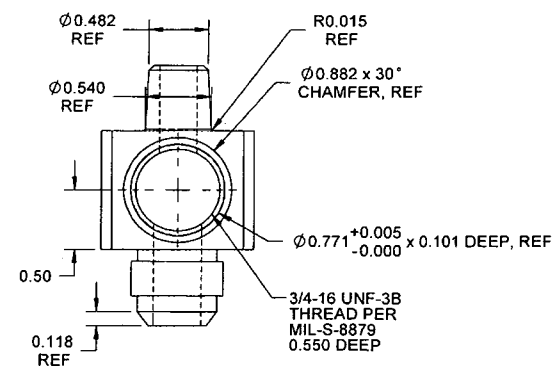
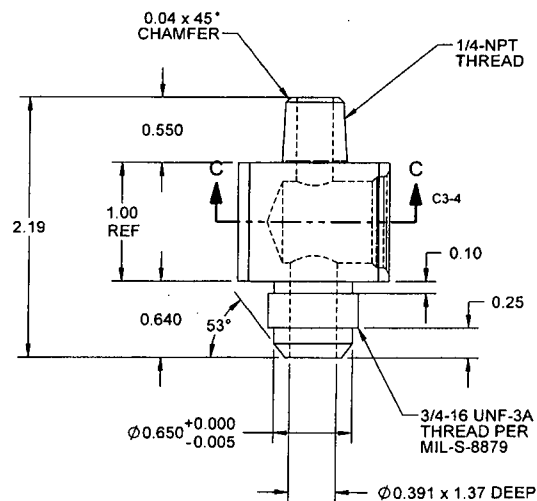
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75979



SECTION C-C C5-4



D3299-7 FITTING

RELEASED
2010-01-16
MJP

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-7" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.40 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3299	REV. C SHEET 4 OF 4
MFG. APPR.	RF	TITLE FITTING	SCALE NTS
DE APPR.	RF	DATE 09.12.30	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15786

Purchase Order Date 1/04/12

PO Print Date 1/09/12

Page Number 1 of 2

Order From :

VC-ROY003

ROYAL BANK VISA

X

X, X

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

Requisition Nbr

Vendor Fax

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

COD

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	75978	D3299-3 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst: Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize							
2	75979	D3299-5 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst: Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize							
3	75977	D3299-7 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst: Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize							

PO Instructions:

VERDUN ANODIZING (ATTN: MARC FOURNIER)
VISA ACCT: 4516 0500 0053 0448 EXP: 0514 CID: 327

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr:

3

Change Date: 1/09/12

**Anodisation Verdun Inc.****Verdun Anodizing Inc.**

3971, ave Verdun, Verdun (Quebec) H4G 1L1

AS 9100:2004

ISO 9001:2000

Certified

info@verdunanodizing.com

Tel: (514) 761-4531

Fax: (514) 769-4731

PACKING SLIP

DARTAERO

DARTAERO

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RDART AEROSPACE LTD.
1270, ABERDEEN STREETHAWKESBURY
Ontario K6A 1K7S
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ODART AEROSPACE LTD.
1270, ABERDEEN STREETHAWKESBURY
Ontario K6A 1K7

[C]

Customer Copy

Attn: CHANTAL LAVOIE 1-613-632-9577 Fax: (613)-632-1053

Customer Order No.	Order Date	Ship Via	No. of Packages	Date Shipped	Reference No.
PO15786	05/01/12	FEDEX	1	09/01/12	273222-00

MIL221BL

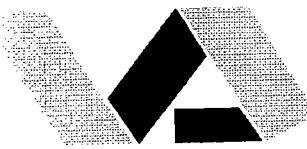
Bleu Sulfuric Anodize: DIW S Rev: P1

Item No.	Part No.	Description	Serial No.	Length	Quantities	
					Processed	Not processed
001	D3299-3	MAT:			8.0	
	LINE:1 FITTING REF:75978					
002	D3299-5	MAT:			8.0	
	LINE:2 FITTING REF:75979					
003	D3299-7	MAT:			8.0	
	LINE:3 FITTING REF:75977					

Total: 24.0 0.0

Remarks:

Customer signature



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Verdun Anodizing Inc.
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AS 9100:2004
ISO 9001:2000
Certified

info@verdunanodizing.com
Tel: (514) 761-4531
Fax: (514) 769-4731

CERTIFICATE OF SUB-CONTRACTOR

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DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

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DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

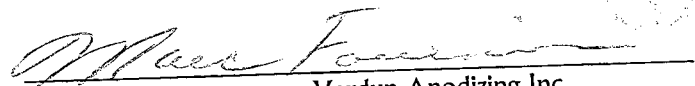
DARTAERO

Customer Order No.	Order Date	Process Date	Certificate No.
PO15786	05/01/12	09/01/12	273222-00

PROCESS: MIL A-8625F1 Ty II Cl 2 BLEU DIW Seal

Item No.	Quantity	Description	Serial #
001	8.0	D3299-3 LINE:1 FITTING REF:75978 MAT:	
002	8.0	D3299-5 LINE:2 FITTING REF.75979 MAT:	8, 12/01/11
003	8.0	D3299-7 LINE:3 FITTING REF.75977 MAT:	

We hereby certify that the parts described above and furnished by DART AEROSPACE LTD. have been treated in accordance with the relevant specifications and that no substitution of materials has been made.


Inspector: Verdun Anodizing Inc.